Thursday, 02/04/2009 7:38:45 AM

User Linda Lacelle

Process Sheet

Customer

Prsht Rev.

First Issue

Written By

Comment

Previous Run

Date

: CU-DAR001 Dart Helicopters Services

Job Number : 46789

Estimate Number : 11645

P.O. Number

This Issue

: 02/04/2009 : NC

: // : 46667

S.O. No. :

Type

B 02.03.98 Added dwg Rev.B NG Est Rev:C 08-04-22 now on water jet DD verified by:

: SMALL /MED FAB

Drawing Revision Material

Drawing Name

Part Number

Drawing Number

Project Number

Due Date

: DOUBLER

: D29921

: N/A

: 02/04/2009

D2992 UNDER

Qty:

10 Um:

Rev. A Roger

Each

Additional Product

Checked & Approved By

Job Number:



Seq. #:

Machine Or Operation:

Description: 5052-H32 .040 Sheet

1.0

M5052H32S040

0.0802 sf(s)/Unit Total: 0.8022 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 0.040" sheet

Batch: 169656

2.0

Comment: Qty.:

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Qwg D2992

Dwg Rev:

Prog Rev:

2-Deburr if necessary

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B9-4-1L

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

SECOND CHECK





Comment: SECOND CHECK

HAND FINISHING RESOURCE



5.0

HAND FINISHING



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



Dart Aer	ospace	e Ltd	~ A					
W/O:		WORK ORDER CHANGES	-Of		<u>-</u>			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr		orova spector
09.04,14	7	PART MADE 4.0" WIDE, PER MARKED-UP DWG	& Lyst			09.04.14 08.04.14	5.0	John

Part No:	_PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	
Resolution:		Disposition:	QA: N/C Closed:	Date:	

NCR: WORK ORDER NON-CONFORMANCE (NCR)									
DATE STEP		Description of NC	Corrective Action Section B			Verification	Ammanual	A	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng		oroval nspector
									·
	1								

NOTE: Date & initial all entries

Date: Thur	rsday, 02/04/2009 7:38:45 AM	
		Process Sheet
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: DOUBLER
Job Number:	46789	Part Number: D29921
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comme	ent: INSPECT POWDER COAT/CHEMICAL CO	ALVERSION POPULACIÓN (12)
7.0	PACKAGING 1	PACKAGING RESOURCE #1
Comme	ent: PACKAGING RESOURCE #1 Identify and Stock	10
	Location:ST 59	/85 09/04/15 XID
8.0	QC21	FINAL INSPECTION/W/O RELEASE
Comme	ent: FINAL INSPECTION/W/O RELEASE	
Job Completion		mr ₉₋₀₄₋₁₅
Job Completion		9-04-15
:		

Dart	Aeros	pace	Ltd
------	--------------	------	-----

Dart Ae	rospace	Ltd							
W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
					:				
i									
					·				
Part No	o:	PAR #:	Fault Cate	egory:	NCR: Yes	No DO	QA:	Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORE	ER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section		Veri	fication	Approval	Approva
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	∖& Se	ction C	Chief Eng	QC inspect
						1			

11011.								
		Decembring of NC		Corrective Action Section B		Verification	Approval	Approva
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspecto
						1		

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46789		
	,				
Description: DOUBLER		Part Number:	Lepped Re		
			/		
Inspection Dwg: D 2492-1 Rev: R			Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.750	4010	3,248	4			
4 ms	+ _ an	4.002	You.			
040,	4-,00	,040	6			
en i						
		<u>.</u>				
				-		
			-			
		·				<u>.</u>
					,	
	:					
						

Measured by:	Audited by:	Prototype Approval:	
Date: 9-4-14	Date: 09/64/14	Date: /g	

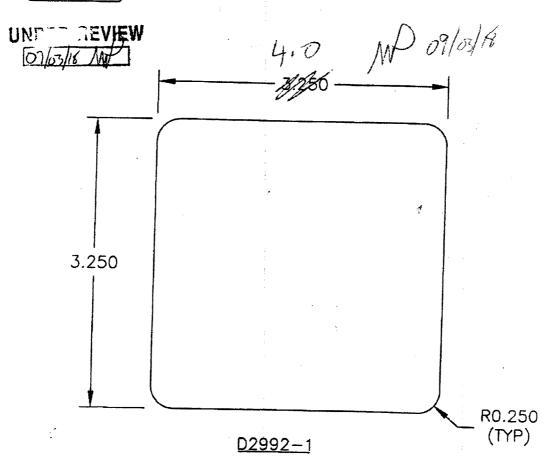
Rev	Date	Change	Revised by	Approved
Α	••	New Issue	KJ/JLM	





DESIG	CP	DRAWN BY	DART AEROSP HAWKESBURY, ONTAI	PACE LTD
CHEC	KED	APPROVED 4	D2992	REV. K
02.0	01.21		mle DOUBLER	SCALE 1:1
A		02.01.21	NEW ISSUE	

PELEASE OF



NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.